

DART AEROSPACE LTD	Work Order :	24030
Description: 427 'I' Beam	Part Number:	D2792 -130
Drawing: D2792 Rev. A	Qty:	52 62

Step	Location	Procedure	By	Date
1	EXPEDITING	Issue work order	U	05.08.10
2	PURCHASING	Issue P/O: <u>7008452</u> a) Extrude as per Dwg D2792 b) Material: 6061-T6 (QQ-A-200/8) c) Tool: MS-19248 d) Material certification is required.	U	05.08.10
3	QC /RG	Inspect for freight damage Receive +	CL	05/09/30 62
4	PURCHASING	Issue P/O: <u>7</u> Send a sample for pull testing <u>N/A</u>		
5	PURCHASING	Attach test report to W/O	CL	05/09/30 62
6	QC	Inspect Level 6 Check Test Report to Dwg D2792 for compliance	2	05.11.17 62 PTO
7	STORES	Tag and Stock	2	05.11.17 62
8	EXPEDITING	Close W/O Cost / Job <u>58.58</u> <u>58.58</u> <u>05/11/21</u> <u>(62)</u>	2	05/11/21 62

Rev	Date	Change	Revised By	Approved
A	98.11.09	New Issue	KS	62

MANUFACTURER RELEASE CERTIFICATION

D.O.T Approval 9-89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

Authorized Inspector


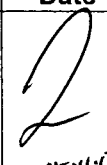

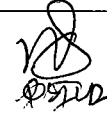
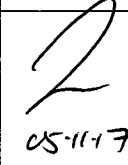
Date

UNDER REVIEW

EC 99.08.25

see 02423

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-11-17	6	minor air bubbles found on inner surface of I beam.		ensure no porosity is found upon web during work process. Identify I beam for employee notification	 05-11-17	 05-11-17		 05-11-17

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/11/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 10, 2005
07:35 am

Work Order No	: 0024030	Department Code:	
Project Name	: D2792-130	Burden Flags	: NNNNNNN
Project For	: WK535	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2792-130	Invoice Number	:
Description	: EXTRUSION	Invoice Amount	: 0.00
Manufactured	: No	Order Entry No	:
Amount Req'd	: 0	OE Value	: 0.00
Amount Done	: 0		
Start Date	: 08-10-05	Est Margin	: 0.000%
Est Finish Date	: 08-31-05	Actual Margin	: 0.000%
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00



PROFILÉS D'ALUMINIUM - ANODISATION - FABRICATION - PEINTURE
ALUMINUM EXTRUSIONS - ANODIZING - FABRICATION - PAINTING

P/S# 500199
NOTRE NUMERO DE COM
OUR ORDER NO

5092119

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ONT

EXPÉDIÉ / SHIP TO

INDICATIONS SPÉCIALES
SPECIAL INSTRUCTIONS

MÊME - SAME

K6A1K7

CUSTOMER P.S.T. : *6122-5207

INDALEX G.S.T. REG NO: R136834041

Required Date:

N° DU CLIENT CUST. NO.		T.P.S. G.S.T.		TAXE DE VENTE PROV. PROV. SALES TAX		N° DE COMM. DU CLIENT CUST. ORDER NO.		DATE DE COMMANDE ORDER DATE		NOTRE DATE DE COMM. OUR ORDER DATE		CONDITIONS TERMS	
201355		XXXXXX				2008452		5/09/16		5/09/16			
VENDEUR SALESMAN		EXPÉDIE PAR SHIP VIA		PAYER PPD.		C.A.D. C.O.D.		F.A.B. F.O.B.		EN BALLOTS BUNDLED AND TAPED		CARTONNÉ CARTONED	
51		NOTRE CAMION OUR TRUCK		X				NOTRE USINE OUR PLANT				CARTONNÉ & INTERCALE CARTONED & INTERLEAVED	

[illegible]

We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures

ISO
9001

Charal Lucero



325 rue Avro
Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120
Fac-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : **DART ACROSPACE LTD**
Adresse / Address : **1270 ABERDEEN STREET**
HAWKESBURY ONT,
K6A 1K7

commande Indalex / Indalex order # : **5092119**

bon de commande / Purchase order # : **2008452**

de matrice / Die # : **MS 19248** Description : **n/a**

Alliage & trempage / Alloy & temper : **6061 T6**

de coulée / Cast # : **36178**

de contrôle / Control # : **96130-1**

Composition chimique typique / Typical chemical composition :

Si:0.72-0.76/ Fe:0.20-0.29/ Cu:0.24-0.28/ Mn:0.06-0.10/ Mg:0.84-0.88/ Cr:0.05-0.09/ Zn:0.08max / Ti:0.04max

Dureté Rockwell E / Rockwell E Hardness : **92 HRE**

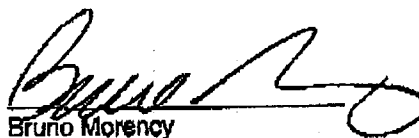
	Min.requis Min.required	Résultat actuel Actual results
Contrainte élastique Yield stress (psi)	35 000	37148
Tension ultime Ultimate stress (psi)	38 000	40190
% élongation dans 2" % elongation in 2"	8	9

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par l'Association de l'Aluminium ainsi que les exigences de nos procédures de contrôle de qualité.

We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our quality control procedures.

Sincèrement vôtre,
Yours truly,

date : 2005-09-22


Bruno Morency
Technicien de la qualité
Quality technician

Indalex Limited



INDALEX LIMITED
325 AVRO Street
POINTE-CLAIRE, QC H9R 5W3
TELEPHONE: (514) 697-5120 & (800) 563-5130
FACSIMILE: (514) 694-8310 & (800) 563-8310

FACSIMILE TRANSMITTAL SHEET

TO: Christina Young

FROM: Bruno Morency
Quality Technician

COMPANY:

DART AEROSPACE LTD

DATE:

2005/09/22

FAX NUMBER:

(613) 632-4443

TOTAL NO. OF PAGES INCLUDING COVER:

2

PHONE NUMBER:

SENDER'S REFERENCE NUMBER:

SUBJECT:

REPORT

TIME:

☐ URGENT☐ FOR REVIEW☐ PLEASE COMMENT☐ PLEASE REPLY☐ PLEASE RECYCLE

NOTES/COMMENTS:

Mechanical properties report

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:49 am

Work Order No : 0024030
Project Name : D2792-130
Project For : WK535
Work Order Type : Main
Main WO Number :
House Part Number : D2792-130
Description : EXTRUSION
Manufactured : Yes
Amount Req'd : 52
Amount Done : 0
Start Date : 08-10-05
Est Finish Date : 08-31-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	3631.96	100.00	0.00	3631.96
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	3631.96	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	3631.96			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-3631.96)

MIS J/B
11.15

Date: Monday, 14/11/2005 3:34:44 PM
 User: Alba Panzuto

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 427 "I" BEAM
Job Number	: 24030		
Estimate Number	: 10369		
P.O. Number	:	Part Number	: D2792130
This Issue	: 14/11/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2792 REV A1
First Issue	: / /	Project Number	:
Previous Run	:	Drawing Revision	: A1
	Type : PURCHASED PARTS	Material	:
Written By	: _____	Due Date	: 30/11/2005
Checked & Approved By	: _____	Qty:	52
Comment	: Est. A 98.11.09 New Issue KS	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: _____

- a) Extrude as per Dwg D2792
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Tool: MS-19248
- d) Material certification is required.
- e) 130 is equal to 130.0"

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

3.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: _____

- 1-Send a sample for pull testing
- 2-Attach test report to W/O

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect Level 6
 Check Test Report to Dwg D2792 for compliance

Date: Monday, 14/11/2005 3:34:44 PM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 427 "I" BEAM

Job Number: 24030

Part Number: D2792130

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

